

Work Order ID 89039

89039

Page 1

August-21-12 9:51:10 AM

Item ID: D139-799-013 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cargo Door Hinge
 Start Date: 8/21/12 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 8/24/12 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: *V* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9613	A
IIN-D139-799	F

100 *SP* 0.00
 100
 DC Memo 0.00
 Document Control Photocopy bluefile & type labels per PPP D139-799-013
 CHG005 *DAS 16 2-30 12/9/26*

110 Pick Kit 0.00
 110
 Packaging Memo 0.00
 Packaging

12/9/26
(6)

12/9/25
Sal

SP

Picklist Print

August-21-12 9:51:07 AM

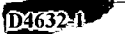





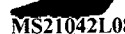





Page 1

Work Order ID: 89039
Parent Item: D139-799-013
Parent Item Name: Cargo Door Hinge

Start Date: 8/21/12
Start Qty: 6.00

Required Date: 8/24/12
Required Qty: 6.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:JLM
11-06-05 JLM VERIFIED BY:DD
IPP REV:C AS PER DSI9567 revA 11.10.17 DD VERF:EC
ecn 12-507 DD verf:EC
IPP REV:B AS PER ECN 11-598
IPP REV:D 12.01.19 per iin rev.f
IPP REV:E 12.06.14 per ecn 12-606 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S ₄₆  Striker Plate		Manufactured	No			110	Each	14.0000	 6	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		-3							
				86207		14			6				
				ST117		17							
S ₄₆  Striker Plate		Manufactured	No			110	Each	14.0000	 6	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST116		14							
				86209		14			6				
S ₄₆  Nut		Purchased	No			110	Each	1,137.0000	 8	48			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				315		336							
				122452		336			47				
				ST300		1			1				
				121524		1							
				ST317		800							
				122141		800							
S ₄₆  Screw		Purchased	No			110	Each	92.0000	 8	48		11/22/594 12/9/26	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				Self	
				Mezz		92							
				11788		92							

Picklist Print

August-21-12 9:51:07 AM

Page 2

Work Order ID: 89039
 Parent Item: D139-799-013
 Parent Item Name: Cargo Door Hinge
 MS27039-08-07
 Screw

Start Date: 8/21/12

Required Date: 8/24/12

Start Qty: 6.00

Required Qty: 6.00

Purchased No

110 Each 476.0000

8 5/48 SP

Location

Loc Qty

Loc Code

ST307

476

122563

476

48

Purchased No

110 Each 783.0000

8 48 33 122973 SP

Location

Loc Qty

Loc Code

ST297

658

121708

658

15

ST298

125

105793

12

110985

4

117087

89

119717

15

120644

5

15

Purchased No

110 Each 2,099.0000

8 48 SP SP

Location

Loc Qty

Loc Code

297

2000

122441

2000

15

ST298

99

119717

41

120422

58

15

Manufactured No

110 Each 36.0000

12/9/26 5/48 SP

Location

Loc Qty

Loc Code

ST011

36

73297

2

85425

34

6

NAS1149D0332J
 Washer

NAS1149DN832J
 WASHER

D2585
 Mounting Channel

August-21-12 9:51:08 AM

Shop Packet Print

Page 2

Picklist Print

August-21-12 9:51:08 AM

Work Order ID: 89039

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 8/21/12

Required Date: 8/24/12

Start Qty: 6.00

Required Qty: 6.00

See D2586 Door Latch	Manufactured	No		110	Each	57.0000	U 516	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST203A	57				
See D2621 Latch Plate, 350 Spacepod	Manufactured	No		110	Each	25.0000	U 6	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			78833	1				
See D3552-23 Door Prop	Manufactured	No		110	Each	17.0000	U 6	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST013	25				
See D3622-1 Ball Stud	Manufactured	No		110	Each	6.0000	U 6	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			74847	6				
See D3622-3 Ball Stud	Manufactured	No		110	Each	11.0000	U 6	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST058	6				
See D4072-1 Airframe Hinge	Manufactured	No		110	Each	0.0000	U 12	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			82072	6				
			53951	4				
			82595	7				

August-21-12 9:51:08 AM

Shop Packet Print

Picklist Print

Page 4

August-21-12 9:51:08 AM

Work Order ID: 89039

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 8/21/12

Required Date: 8/24/12

Start Qty: 6.00

Required Qty: 6.00

S
D4072-3
Airframe Hinge Backing Plate

Manufactured No

110 Each 18.0000

2 *10x*
889196 *12* *sl*

Location

Loc Qty

Loc Code

ST090

18

78529

2

82837

16

2

S
D4072-5
Bushings

Manufactured No

110 Each 30.0000

4 *sl* *24*

Location

Loc Qty

Loc Code

ST

30

86206

30

24

S
D4073-1
Door Hinge

Manufactured No

110 Each 14.0000

2 *sl* *12*

Location

Loc Qty

Loc Code

ST091

12

86208

12

12

ST120

2

82355

2

S
D4073-3
Door Hinge Backing Plate

Manufactured No

110 Each 12.0000

2 *10x*
889046 *12* *12/9/12* *sl*

Location

Loc Qty

Loc Code

ST

-8

82213

1

ST090

11

78527

1

82842

10

ST120

9

8

August-21-12 9:51:08 AM

Shop Packet Print

Page 4

Picklist Print

August-21-12 9:51:08 AM

Page 5

Work Order ID: 89039

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 8/21/12

Required Date: 8/24/12

Start Qty: 6.00

Required Qty: 6.00

S
S
D4074-1
Bracket
Manufactured No 110 Each 18.0000 0 6 sel

Location Loc Qty Loc Code

ST091 16

86205 16

ST120 2

76338 2

4x

2x

S
S
D4074-3
Channel
Manufactured No 110 Each 13.0000 0 6 sel

Location Loc Qty Loc Code

ST091 13

80696 13

6

S
S
D4074-5
Backing Plate
Manufactured No 110 Each 82.0000 0 6 sel

Location Loc Qty Loc Code

ST120 82

74495 80

76339 2

6

S
S
D4074-7
Striker Plate
Manufactured No 110 Each 6.0000 0 6 sel

Location Loc Qty Loc Code

ST091 6

75624 6

S
S
D4519-1
Relay Bracket
Manufactured No 110 Each 9.0000 0 6 sel

Location Loc Qty Loc Code

ST114 9

79090 9

August-21-12 9:51:09 AM

Shop Packet Print

Page 5

Picklist Print

August-21-12 9:51:09 AM

Page 6

Work Order ID: 89039
 Parent Item: D139-799-013
 Parent Item Name: Cargo Door Hinge

Start Date: 8/21/12
 Start Qty: 6.00

Required Date: 8/24/12
 Required Qty: 6.00

MS21042L3
 Nut

Purchased No

110 Each 3,235.0000

28 12/9/12 168 sl

Location	Loc Qty	Loc Code
316	795	
122452	795	
ST300	728	
117885	32	
119017	558	168
119075	138	
ST317	1712	
122141	1712	

MS21042L5
 Nut

Purchased No

110 Each 1,670.0000

12/9/12 6 sl

Location	Loc Qty	Loc Code
300	492	
121652	492	
314	1000	
122452	1000	
ST300	178	
108827	4	
116105	1	
116548	43	
119109	118	6
2937	12	

August-21-12 9:51:09 AM

Shop Packet Print

Page 6

Picklist Print

August-21-12 9:51:09 AM

Page 7

Work Order ID: 89039

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 8/21/12

Required Date: 8/24/12

Start Qty: 6.00

Required Qty: 6.00

MS27039-1-10
Screw

Purchased No

110 Each 224.0000

8

48

5/1



Location Loc Qty Loc Code

308 100

122441 100

GA 100

120449 100

ST291 5

120120 5

ST308 19

122027 19

47x

1x

MS27039-1-14
Screw

Purchased No

110 Each 171.0000

2

12



Location Loc Qty Loc Code

GA 154

120177 54

120449 100

ST291 17

112312 17

12

MS27039-1-16
Screw

Purchased No

110 Each 86.0000

8

48



Location Loc Qty Loc Code

ST291 86

119902 1

120229 35

121444 50

27

21

MS27039-1-17
Screw

Purchased No

110 Each 101.0000

1

12/1/12

5/1



Location Loc Qty Loc Code

GA 92

120142 92

ST291 9

117591 9

1

5x

August-21-12 9:51:09 AM

Shop Packet Print

Page 7

Picklist Print

August-21-12 9:51:09 AM

Work Order ID: 89039
Parent Item: D139-799-013
Parent Item Name: Cargo Door Hinge

Start Date: 8/21/12 Required Date: 8/24/12
Start Qty: 6.00 Required Qty: 6.00

NAS1149D0363J
Washer

Purchased No

110 Each 5,044.0000

18 108

Location	Loc Qty	Loc Code
ST297	4606	
122378	4606	
ST298	438	
116025	1	
117601	61	
119537	33	
120142	13	
120308	17	
121243	209	
121524	104	

108

NAS1449D0663J
Washer

Purchased No

110 Each 422.0000

0 11/23/21

Location	Loc Qty	Loc Code
298	422	
122452	422	

NAS1515H5L
WASHER

Purchased No

110 Each 131.0000

4 24

Location	Loc Qty	Loc Code
FG	40	
103691	40	
ST277	91	
119902	1	
122049	90	

IN4007
Diodes

Purchased No

110 Each 29.0000

24 12/19/25

Location	Loc Qty	Loc Code
ST390	11	
120363	11	
ST395	18	
114970	9	
117871	9	

10

August-21-12 9:51:10 AM

Shop Packet Print

Picklist Print

August-21-12 9:51:10 AM

Page 9

Work Order ID: 89039

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 8/21/12

Required Date: 8/24/12

Start Qty: 6.00

Required Qty: 6.00

M12883/41-19

Relay Base

Purchased No

110 Each 20.0000

Location

Loc Qty

Loc Code

ST395

20

120251

9

122097

11

Purchased No

110 Each 114.0000

Location

Loc Qty

Loc Code

ST511

114

120344

33

120363

81

Purchased No

110 Each 20.0000

Location

Loc Qty

Loc Code

ST395

20

120251

9

122097

11

M83536/9-024M

Relay

S
H
M
S
H

sel 6
sel 24
sel 12/9/25
sel

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-799 REV. F AND ICA-D139-799 REV. 5

REF. FAA STC: SR02138SE
REF EASA STC EASA.10038656

REFERENCE ONLY

PURPOSE

The purpose of this DSI is to clarify the installation of the D139-799-013 Cargo Door Fwd Opening Kit on aircraft that are equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors with two gas springs (see Figure 3b of IIN-D139-799 Rev. F).

PROCEDURE

Amend IIN-D139-799 Rev.F steps as follows:

- 3.2.1.2 Remove left/right hinges from the doors as shown in Figure 3a including the door open switches on the fwd hinge bracket. Remove left/right gas spring hinges (if installed) from the door as shown in Figure 3b. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors, remove 3P5230A15631 and 3P5230A15731 hinge brackets from the airframe as shown in Figure 1 of this DSI.
- 3.2.2.10 Install the D4074-7 Striker Plate using 4 x CR3523-4 rivet as shown in Figure 5c Section G-G. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Door, trim Doorframe Channel as shown in Figure 2 of this DSI to allow space for alternate D4632-1 (LH) and D4632-2 (RH) striker plates. Install alternate D4632-1/2 striker plate at the aft airframe hinge bracket location (see Figure 2 of this DSI). Transfer drill 4 x holes from 3P5340A31951 doubler to striker plate, and install using MS24694-S47 screw, NAS1149D0332J washer and MS21042L3 nut in 4 places.
- 3.2.2.11 Install D4074-1/-5 Bracket/Backing Plate using the existing holes in the cargo door as shown in Figure 5b Detail E. Plug holes at center of the door used for original gas springs using existing hardware. Torque screws per Table 1. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Door, plug existing holes with Hysol EA934NA. Locate D4074-1 bracket at bottom of existing recess and transfer hole locations to door as shown in Figure 4 of this DSI. Install D4074-1/-5 brackets using hardware shown in Figure 5b Detail E of IIN-D139-799 Rev. F.
- 3.2.2.12 Install D4074-3 Channel using existing hardware in original gas spring cut out as shown in Figure 5d Section I-I. On aircraft equipped with 3P5230A01033 (LH) and 3P5230A01133 (RH) Cargo Doors, trim Doorframe Cover as shown in Figure 3 of this DSI to expose bottom side of Doorframe Channel. Locate D4074-3 Channel as shown in Figure 3 of this DSI and transfer 4 x $\phi 0.173$ " (#17 drill) from the D4074-3 Channel to the Doorframe Channel. Install D4074-3 Channel using MS27039-0807 screw, NAS1149DN832J washer and MS21042L08 nut in 4 places.

PART LIST

Note: The following parts are included in D139-799-013 at CHG 005 and later. For customers who already have D139-799-013 at CHG 004 and earlier, procure the DSI 9613-011 kit from Dart.

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9613-011	CARGO DOOR HINGE MOD KIT
1	D4632-1	STRIKER PLATE
1	D4632-2	STRIKER PLATE
8	MS24694-S47	SCREW
8	MS27039-0807	SCREW
8	NAS1149DN832J	WASHER
8	NAS1149D0332J	WASHER
8	MS21042L08	NUT
8	MS21042L3	NUT

WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance

A	NEW ISSUE	RF	12.05.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9613	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CARGO DOOR HINGE MOD	NTS
DATE	12.05.29	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

REFERENCE ONLY

Qty -013	Part Number	Description
X	D139-799-013	CARGO DOOR HINGE KIT
1	D2585	MOUNTING CHANNEL
1	D2586	DOOR LATCH
1	D2621	LATCH PLATE
1	D3552-23	DOOR PROP
1	D3622-1	BALL STUD
1	D3622-3	BALL STUD
2	D4072-1	AIRFRAME HINGE
2	D4072-3	AIRFRAME HINGE BACKING PLATE
4	D4072-5	BUSHING
2	D4073-1	DOOR HINGE
2	D4073-3	DOOR HINGE BACKING PLATE
1	D4074-1	BRACKET
1	D4074-3	CHANNEL
1	D4074-5	BACKING PLATE
1	D4074-7	STRIKER PLATE
1	D4519-1	RELAY BRACKET
1	IN4007	DIODE
1	M12883-41-19	RELAY BASE
4	M39029/92-534	SOCKET CONTACT
1	M83536/9-024M	RELAY
20	MS21042L3	NUT (or MS21042-3)
1	MS21042L5	NUT (or MS21042-5)
8	MS27039-1-10	SCREW
2	MS27039-1-14	SCREW
8	MS27039-1-16	SCREW
1	MS27039-1-17	SCREW
18	NAS1149D0363J	WASHER (or AN960JD10)
1	NAS1149D0663J	WASHER (or AN960JD616)
4	NAS1515H-5L	WASHER

Qty -023	Part Number	Description
X	D139-799-023	ANTI-ROTATION BLOCK KIT
5	D4310-1	BLOCK, ANTI-ROTATION
10	MS24665-115	PIN, COTTER

• COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: F
Date: 11.10.20